

Date: Monday, 3/17/2008 11:57:08 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE		
Job Number	: 38035					
Estimate Number	: 10006					
P.O. Number	:			Part Number	: D2889	
This Issue	: 3/17/2008		S.O. No.	: D2889 REV B		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: LANDING GEAR		
Previous Run	: 38034			Drawing Revision	: B	
Written By	:			Material	:	
Checked & Approved By	: <i>JLM 03/17</i>			Due Date	: 4/4/2008	
Comment	: Est Rev:A		New Issue	05-10-25	JLM	Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	<i>B23763</i>

EL 8-4-8

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-4-8

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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see attachment

Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

08-04-07

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

08/04/08

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

Inside and outside of tube

u/g S. Salaffes used on w/b # 380360

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

→ used in w/o 38360

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-10

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

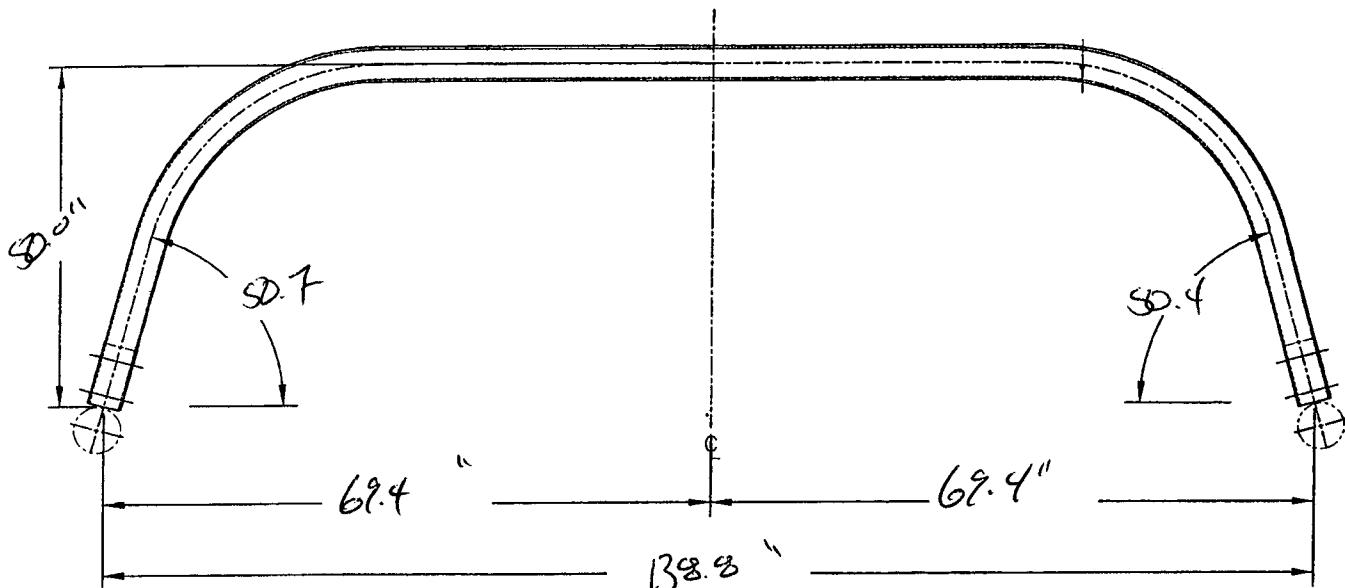
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38035
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

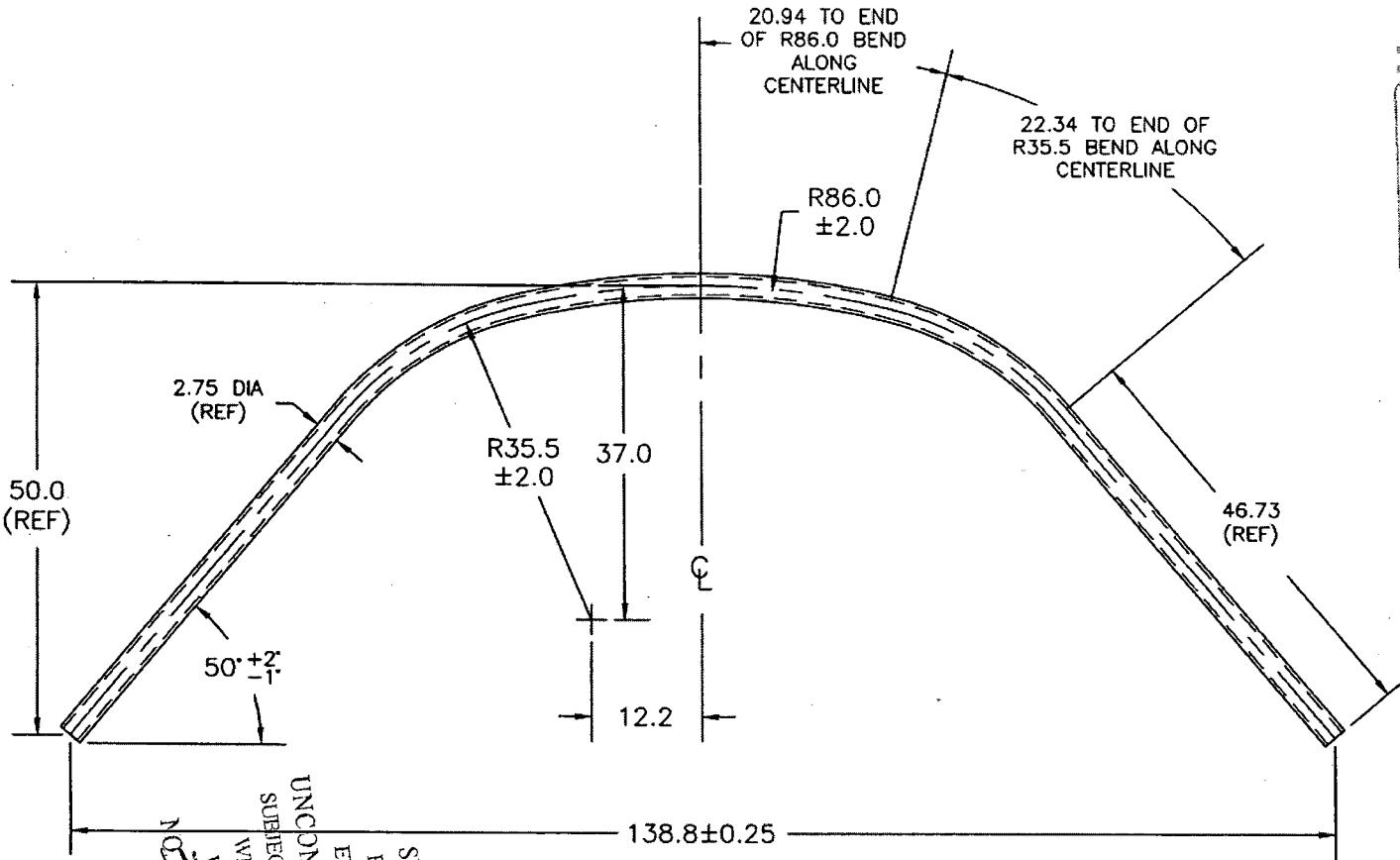
Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used on w/b 38360

QC15 Inspection	
Date	02/04/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	JM



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\varnothing 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED
02-10-28

DART
DART AEROSPACE LTD

02-10-28
GAGORI
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD
	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
	CP	D2889
DATE		REV. B
02.10.18		SHEET 1 OF 1
A	99.05.21	TITLE
		FWD CROSSTUBE
B	02.10.18	SCALE
		1:20
		ADD TANGENT LENGTHS; CHANGE NOTES

Date: Friday, 04/04/2008 1:08:46 PM
 User: Melanie Fauteux

Process Sheet

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Job Number	: 38035		Part Number	: D2889		
Estimate Number	: 10006		Drawing Number	: D2889 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 04/04/2008	S.O. No. :	Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: 17/03/2008	Type	: LANDING GEAR			
Previous Run	: 38034		Due Date	: 04/04/2008	Qty:	1 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A		New Issue	05-10-25	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
		 REFERENCE ONLY
Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish		
 <i>N/A 06/04/14</i>		

Job Completion